

Date: Thursday, 13/11/2008 1:05:46 PM
 User: Julie Dawson

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	OUTSIDE WASHER
Job Number :	43416		
Estimate Number :	11154		
P.O. Number :		Part Number :	D32335
This Issue :	13/11/2008	Drawing Number :	D3233 REV B
Prsht Rev. :	NC	Project Number :	N/A
First Issue :	/ /	Drawing Revision :	B
Previous Run :	37647	Material :	
Written By :		Due Date :	02/12/2008
Checked & Approved By :	<u>JUL 08.11.14</u>	Qty:	10
Comment :	Est. A 05.03.14 New issue KJ/JLM Est Rev:B Now on Doosan Lathe 08-04-01 JLM Verified by:EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M1020TR1875W250	ROUND TUBE 1.875 x .250w
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Comment: Qty.: 0.1860 f(s)/Unit Total : 1.8596 f(s)

1020-1025 Round Tube

Material: AISI 1020-1025 Seamless Round Tubing Cold Drawn per MIL-T-5066 or ASTM A513-00 MT1020

SRA or AMS 5075 or AMS 5077

(M1020TR1.875W.250)

Identify for D3233-5

Batch: 102210

08/12/23

2.0	DOOSAN LATHE	DOOSAN LATHE
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Comment: Doosan Lathe

1- Turn as per Folio FA736 Rev: N/A & Dwg D3233 Rev: B

2-Deburr per dwg D3233

08/12/23

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

J.L 08/12/23

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 13/11/2008 1:05:46 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: OUTSIDE WASHER

Job Number: 43416

Part Number: D32335

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

57483 *PC 8/14/24* (10)

6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

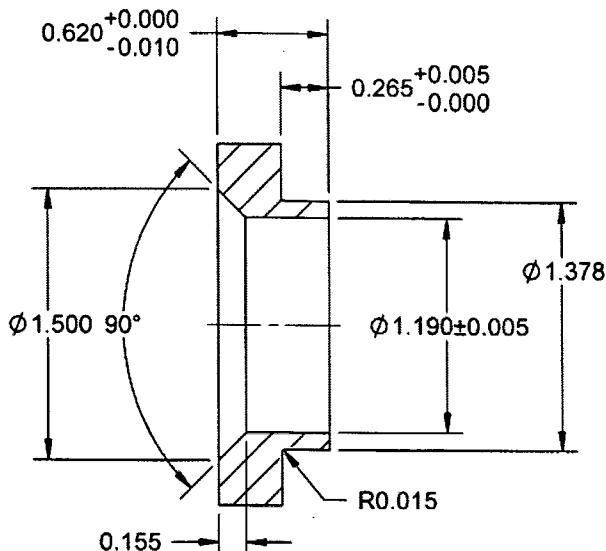
Job Completion



12/08/12.24

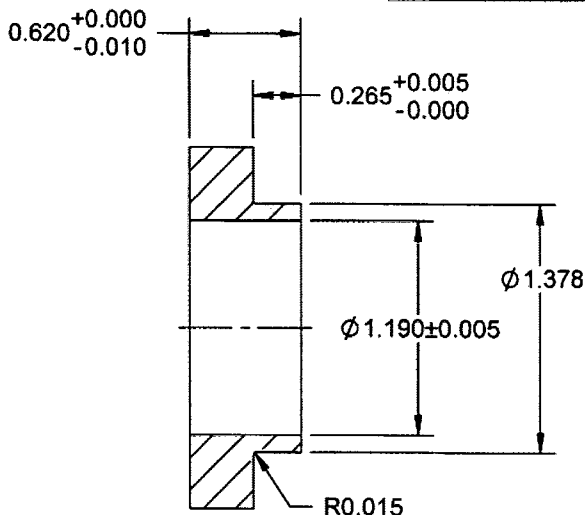
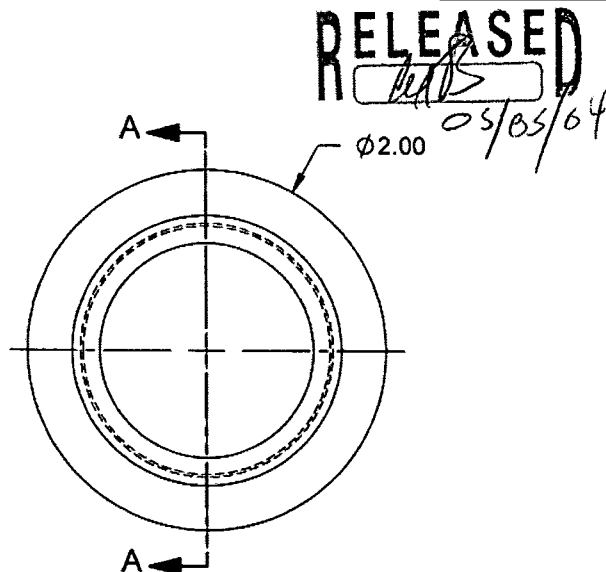


DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3233	REV. B SHEET 2 OF 3
DATE 05.03.08		TITLE WHEEL ASSEMBLY	SCALE 1:1



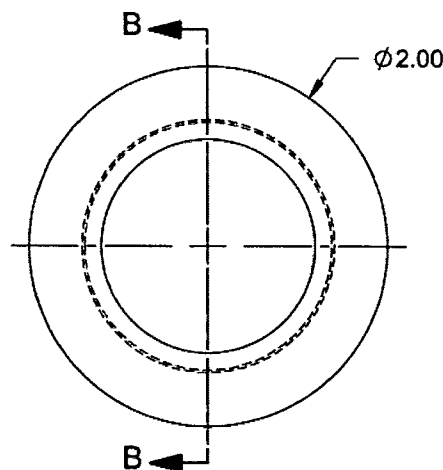
SECTION A-A

D3233-1 INSIDE WASHER



SECTION B-B

D3233-3 OUTSIDE WASHER



NOTES:

- 1) MATERIAL: AISI 1020-1025 ROUND TUBING PER MIL-T-5066 OR ASTM A513-00 MT1020 SRA OR AMS 5075 OR AMS 5077, COLD DRAWN, SEAMLESS (REF. DART SPEC. M1020TR)
- 2) FINISH: POWDER COAT FIRE RED (REF. 4.3.5.10) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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WORK ORDER
NO. 43416

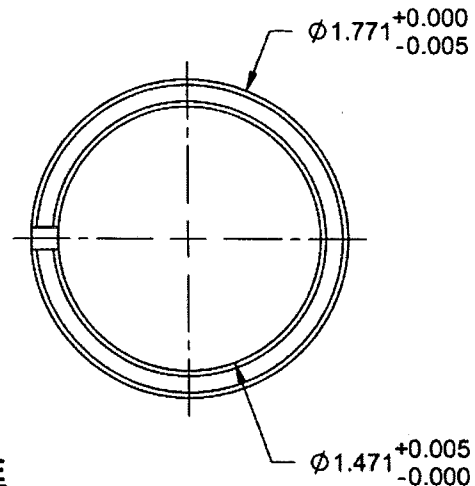
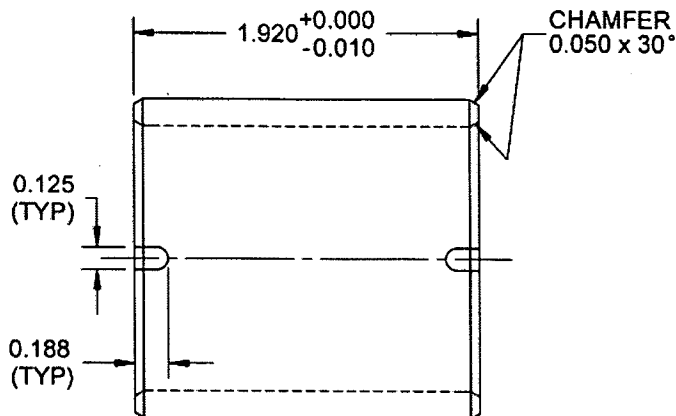
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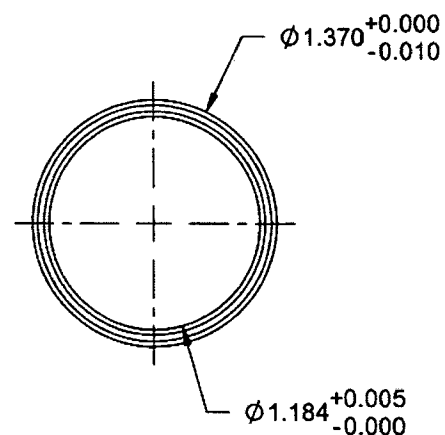
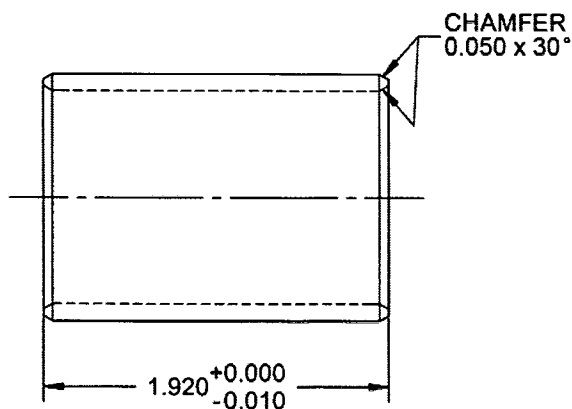


DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3233	REV. B SHEET 3 OF 3
DATE 05.03.08		TITLE WHEEL ASSEMBLY	SCALE 1:1

RELEASED
[Signature]
05/05/04



D3233-5 HUB SLEEVE



D3233-7 SHAFT SLEEVE

NOTES:

- 1) MATERIAL: AISI 1020-1025 ROUND TUBING PER MIL-T-5066 OR ASTM A513-00, MT1020 SRA OR AMS 5075 OR AMS 5077, COLD DRAWN, SEAMLESS (REF. DART SPEC. M1020TR)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.030

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